

304 T.500 X.035w

Work Order ID 115533

\*115533\*

Page 1

April-03-14 9:03:41 AM

Item ID: D3591-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bushing

Start Date: 4/03/14

Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 4/10/14

Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals:

Process Plan: 

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3591

Rev B

100

0.00

\*100\*

CONVENTIONAL LATHE

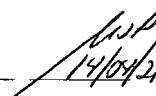
Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per dwg D35912-Debur

~~58~~  
58~~2~~  
2  
14/04/21

110

0.00

\*110\*

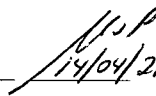
QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

~~58~~  
58~~2~~  
2  
14/04/21

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS  
25  
9-89

144-22

PTO 

DQA:

Date: 11/07/11

QA Closed:

Date: 14-6-27

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>115533</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D3591-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3977</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	14/04/21	100	2	MEASURE 4,100 $\pm$ 0,000 is at 4,093 For the 2 pieces	OS102	SRA P & Destroy	14/04/21	DAS 25 9-89	14/4/22
Operator									
Offset/Setup					14.0423				
Process				RQ $\rightarrow$ OFFSET was not set-up right for the 2 pieces		\$0.80			
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input checked="" type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 115533

April-03-14 9:03:41 AM

**\*115533\***

Page 2

Item ID: D3591-1

Revision ID:

Item Name: Bushing

Start Date: 4/03/14

Required Date: 4/10/14

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Start Qty: 60.00

**\*60\***

Cust Item ID:

Req'd Qty: 60.00

**\*60\***

Customer:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: FG

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

58x

DAS  
28  
9-88

APR 23 2014

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

14/4/24 *[Signature]*

*[Signature]* 4-4-24

# Picklist Print

April-03-14 9:03:40 AM

Page 1

Work Order ID: 115533

**\*115533\***

Parent Item: D3591-1

**\*D3591-1\***

Parent Item Name: Bushing

Start Date: 4/03/14

Required Date: 4/10/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 07.02.01 new issue EC  
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased			No	100	f	258.1412	0.35	23			

**\*M304TR0 500W 035\***

304 RD Tube .500 x .035W

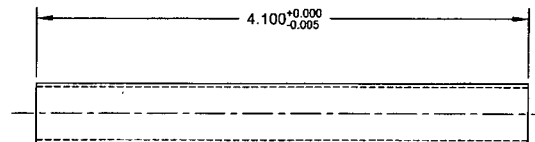
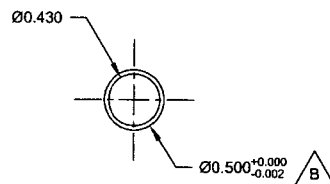
**\*\***

Location	Loc Qty	Loc Code
MAT017	258.1412	
125513	8.1269	
m126922	3	
<u>m128084</u>	127.0143	
m128495	120	

22,080'

*WSP*  
14/04/21

W/O 115533



**D3591-1 BUSHING**

**RELEASED**  
08-04-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING  
REF. DART SPEC M304TR0.500W.035  
OR: AISI 303/304/316 SS, ROUND BAR  
REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

REV. B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DRAWING NO. D3591	REV. B	SHEET 1 OF 1
DATE 08.08.25		TITLE BUSHING	SCALE	NTS
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